

# Work Order ID 57555

April 8, 2010 9:58:58 AM



Page 1

Item ID: D2324

Accept



Setup Start



Revision ID:

Item Name: Strut

10

Stop



Start Date: 4/08/10

Start Qty: 8.00



Cust Item ID:

Required Date: 4/12/10

Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2324

Rev C

100

0.00



Small Fab

*SP 10/04/13*

10

*[Signature]*

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D2324.

110

0.00



QC5- Inspect part completeness to step on W/O

*8/10/04/13*

*(110)*

QC

Memo

0.00

Quality Control

120

0.00



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

*M114207*

*=> 9/10/04/13*

*120*

*[Signature]*

Powdercoat

Memo

0.00

Powder Coating

START TIME: *11:00AM* OVEN TEMPERATURE:

*11:30AM* FINISH TIME:

*320°F*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

PR 10-4-13

(10)

140

Identify as per dwg & Stock Location:

511

0.00



Packaging

Memo

0.00

Packaging

10/4/11 7 (10)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/4/15

PR 10-4-14 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 57555

Parent Item: D2324

Parent Item Name: Strut



Comments: IPP: E03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF

Start Date: 4/08/10

Required Date: 4/12/10

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-12A		Purchased	No			100	Each	48.0000	16.0000			
												
Bolt												

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST351

112720

48

48

AN960JD10

NAS 11449 D03635 <sup>ref</sup> 85B 012

Purchased

No

100

Each

0.0000

32.0000



Washer

D2324-3

Manufactured

No

100

Each

10.0000

8.0000



Bar

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST011

55022

10

10

D2324-5

Manufactured

No

100

Each

93.0000

16.0000



Strap

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST011

52661

55387

93

3

90

20 8/10/04/13

40 8/10/04/13

10 8/10/04/13

3/17 8/10/04/13

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 2

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Work Order ID: 57555



Parent Item: D2324



Parent Item Name: Strut

Start Date: 4/08/10

Required Date: 4/12/10

Comments: IPP: E03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3 		Purchased	No			100	Each	1,331.000	16.0000			
Nut												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST300

1331

113537

347

113644

984

20 10/04/13

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Shop Packet Print

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

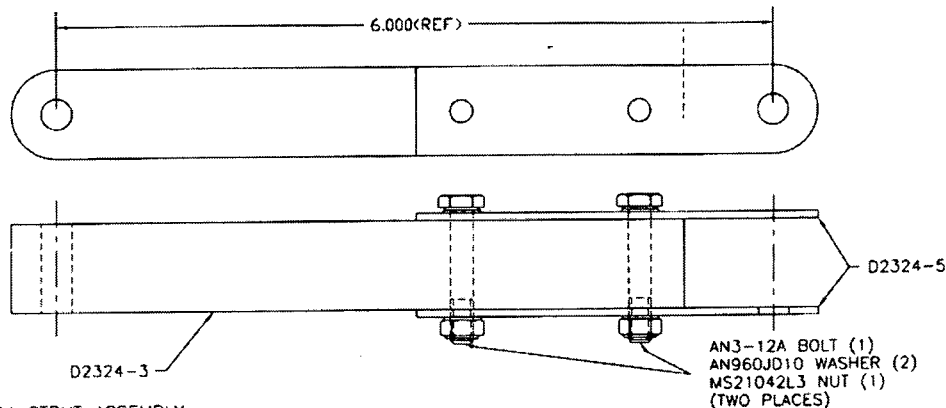
**NOTE:** Date & initial all entries





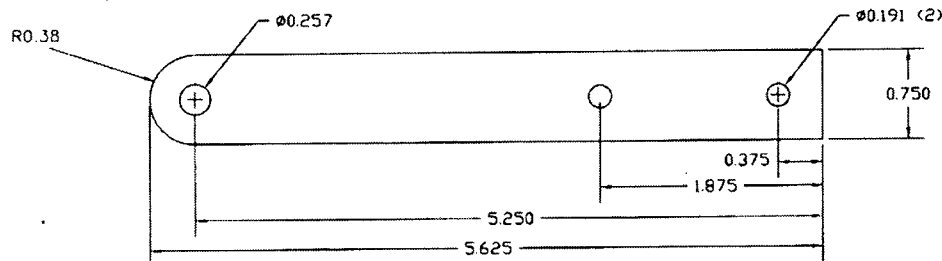
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO.	REV. C
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D2324	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	STRUT		
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED  
04.12.16 *[Signature]*



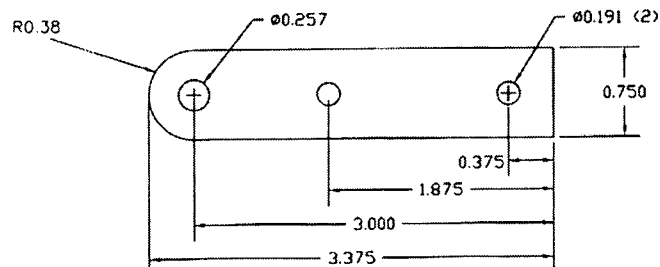
#### D2324 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



#### D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

# 5S basics

- **Sort (Seiri) (整理):** Sorting. Refers to the practice of going through all the tools, materials, etc., in the work area and keeping only essential items. Everything else is stored or discarded. This leads to fewer hazards and less clutter to interfere with productive work.
- **Set in order (Seiton) (整頓):** Simplifying. Focuses on the need for an orderly workplace. "Orderly" in this sense means arranging the tools and equipment in an order that promotes work flow. Tools and equipment should be kept where they will be used, and the process should be ordered in a manner that eliminates extra motion.
- **Shine (Seisō) (清掃):** Sweeping, Systematic Cleaning, or Shining. Indicates the need to keep the workplace clean as well as neat. At the end of each shift, the work area is cleaned up and everything is restored to its place. The key point is that maintaining cleanliness should be part of the daily work - not an occasional activity initiated when things get too messy.